

Blue

Date: Wednesday, 03/09/2008 10:25:59 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE			
Job Number	: 41719		Part Number	: D29392			
Estimate Number	: 10937		Drawing Number	: D2939 REV C - BLUE			
P.O. Number	:		Project Number	: N/A			
This Issue	: 03/09/2008	S.O. No. :	Drawing Revision	: C			
Prsht Rev.	: NC		Material	:			
First Issue	: / /		Due Date	: 26/09/2008			
Previous Run	: 41441		Qty:	4 Um: Each			
Written By	:						
Checked & Approved By	<u>JUL 08.9.03</u>						
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069)		EC				
	Est Rev:C As per Rev C 07-03-19 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No: <u>BS 34872</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr	<u>28/08/08 ④</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>28/08/08 ④</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>28/08/08 ④</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:59 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/09/08

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(LX)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-A 08/09/11

7.0 SPRAY PAINTING SPRAY PAINTING



(PW)

Comment:

-PRIME

B106729

-SPRAY PAINT DELFLEET BLUE B105918

-CLEAR DELFLEET B105917

) ml

08 09 25

(4)

8.0 QC14 INSPECT SPRAY PAINT



108-09-25 (7)

Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

8/9/25

SO

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/26 (7)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2939-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 41719		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-09-24	7.0	Primer is slightly visible on the edges of the saddle.  R.C: Primer is slightly lighter in color than the base.	Q51042	- Scuff & repaint per QS1005  - Next order, grey primer will be used.	MM 08-09-24	108-09-25	051042	108-09-24

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41719
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.123	.123	.123	
B	0.100	0.140		.123	.123	.124	.123	
C	0.100	0.140		.119	.114	.118	.118	
D	0.210	0.230		.223	.223	.224	.225	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.510	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.256	.256	.256	.256	
L	0.312	0.317		.316	.316	.316	.316	
M	0.235	0.240		.238	.238	.258	.258	
N	0.100	0.140		.123	.123	.123	.123	
O	0.540	0.560		.549	.550	.550	.550	
P	0.490	0.510		.504	.504	.500	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.742	2.740	2.740	2.740	
S	0.240	0.270		.2498	.2500	.2500	.2500	
T	0.100	0.180		.140	.140	.135	.135	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.320	.320	.720	.720	
X	1.250	1.270		1.265	1.262	1.265	1.265	
Y	1.565	1.585		1.580	1.578	1.578	1.578	
Z	0.178	0.198		1.188	.188	.188	.188	
AA								
AB								
AC								
AD								

#### Accept/Reject

Measured by: SL 08/09/08 / 8808/09/08

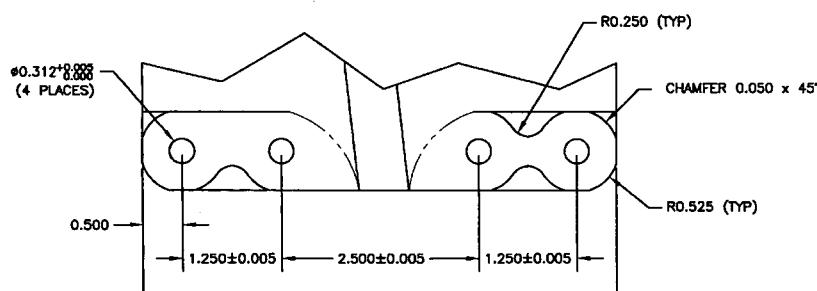
Date:

Audited by: SL 08/09/08

Date:

Prototype Approval: N/A Date: N/A

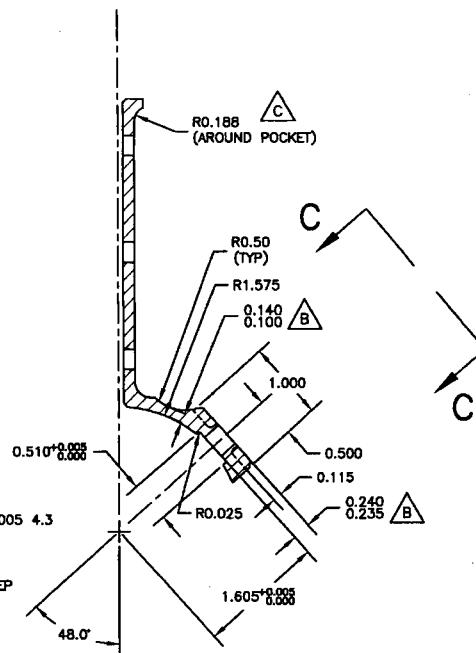
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



VIEW C-C

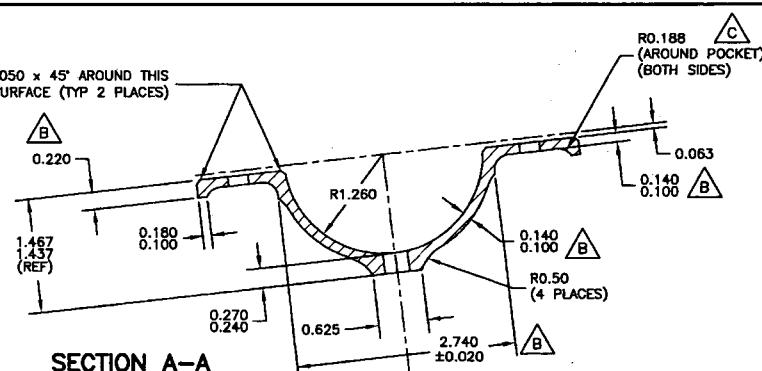
D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

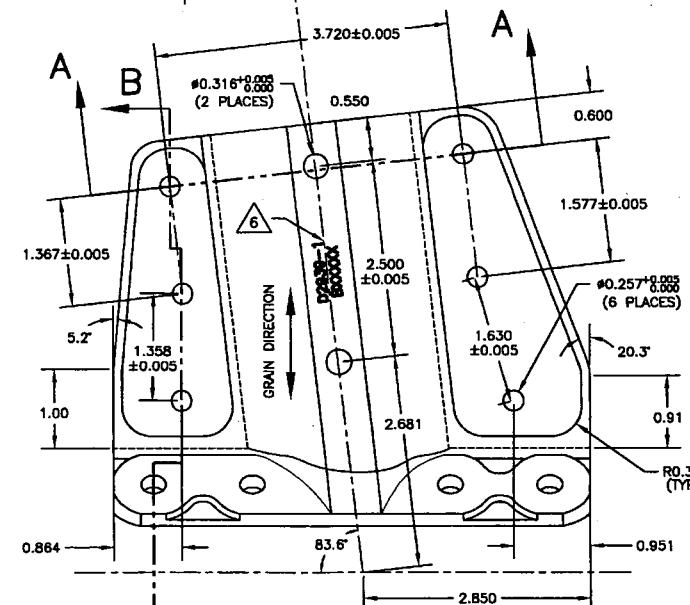


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN DRAWN BY		
PH	CB	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED APPROVED		DRAWING NO. REV. C
PH		D2939 SHEET 1 OF 1
DATE	06.11.09	TITLE SCALE
		SADDLE INSIDE 2:3

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07.02.12 PH